

Date: Monday, 22/10/2007 2:17:12 PM  
User: Linda Lacelle

## Process Sheet

Split 1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM  
Job Number : 35295-2  
Estimate Number : 12578  
P.O. Number : N/A Part Number : D3560041  
This Issue : 22/10/2007 S.O. No. : N/A Drawing Number : D3560 UNDER REVIEW  
Prsht Rev. : NO Project Number : N/A  
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C  
Previous Run : 35029 Material : N/A  
Written By : Due Date : 29/10/2007 Qty: 2 Um: Each  
Checked & Approved By :  
Comment : Est Rev: A New Issue 07.05.24 EC  
est rev B ECN 987 07.10.09 EC verified by: DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total : 20.5065 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M105950

J.L 07/10/24 (12)

2.0 BAND SAW BAND SAW :



Comment: BAND SAW

Cut blanks 16.750" long

J.L 07/10/24 (12)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA &amp; Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

SA/BG 07-10-29 (12)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA/BG 07-10-29 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35295

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25 07/10/31 (12)

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

PLATE 3 35331

14 07-11-29 2

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad )
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch ( 109 )
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

14 07-11-29 2

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15 07/10/30 (42)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16 07-11-30 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 9/12/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: ARM

Job Number: 35295

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-12-03 (2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

07-12-03 (x2)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

batch: B35330 (x2)

MF

07-12-03

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

mf

07-12-03 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J

17/12/03 (x2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~WAST~~

17/12/10 18 07/12/04

x

2

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)  
12/12/10

Job Completion



U mi  
2007/12/10

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

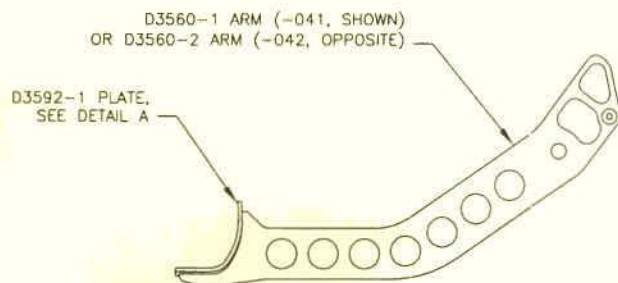
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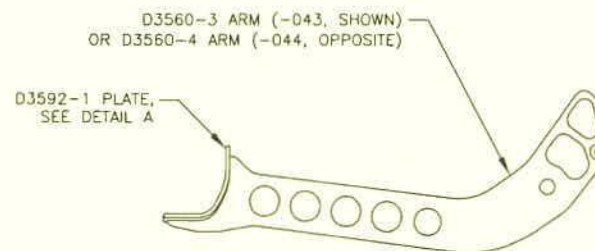
NOTE: Date & initial all entries



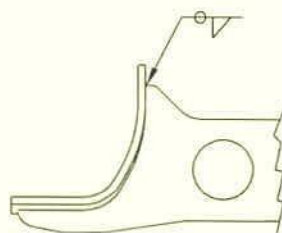
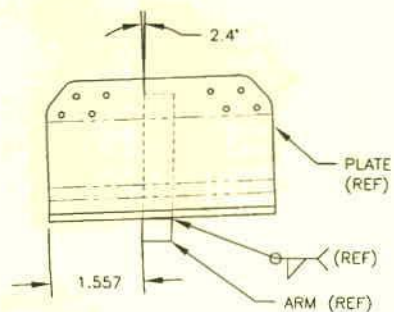
56545  
wlo 3-95



D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19  
**UNDER REVIEW**  
07.10.22 DC

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	H	APPROVED H
DATE	07.06.19	TITLE
		ARM WELDMENT
		SCALE 1:4

**DART** DART AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

DRAWING NO. D3560 REV. C SHEET 1 OF 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

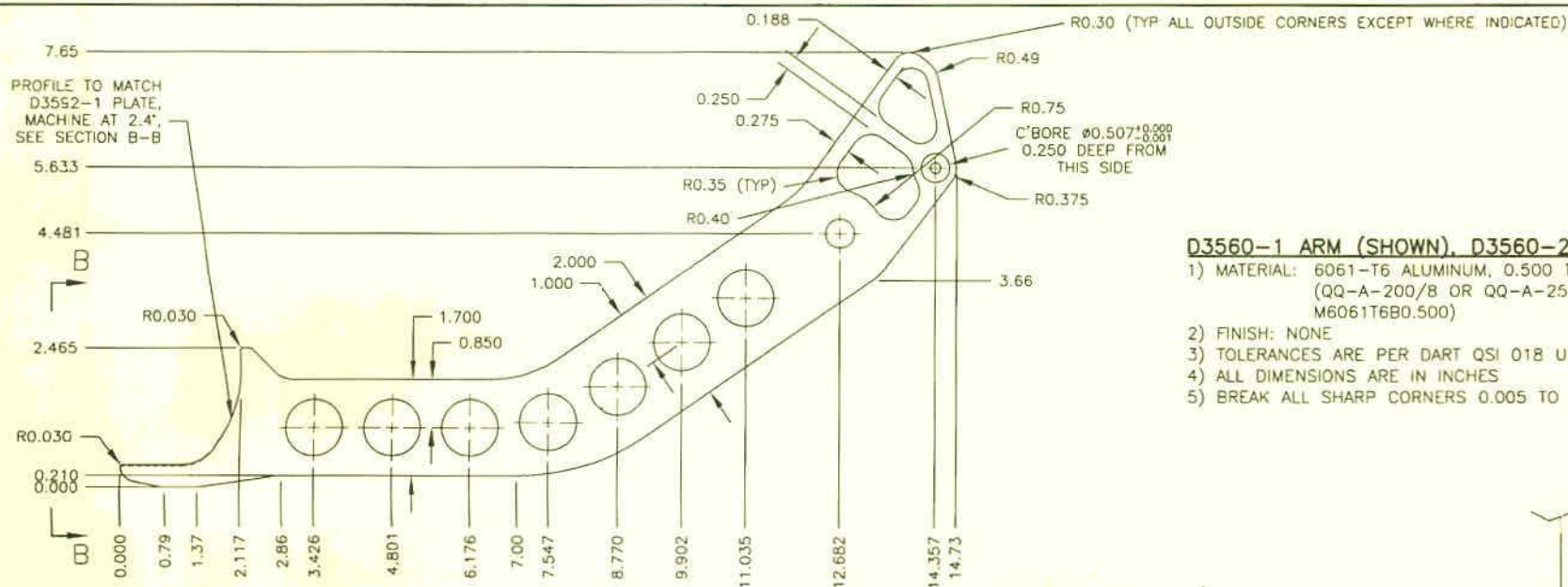
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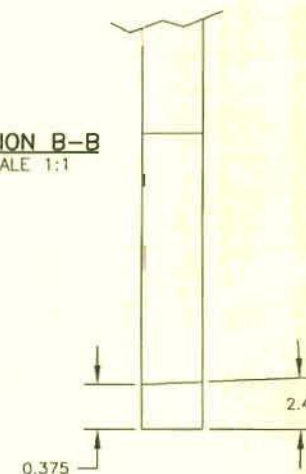




### D3560-1 ARM (SHOWN). D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

### SECTION B-B SCALE 1:1



**RELEASED**  
07.06.19

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DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560	REV. C SHEET 2 OF 3
DATE 07.06.19		TITLE ARM WELDMENT	SCALE 1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

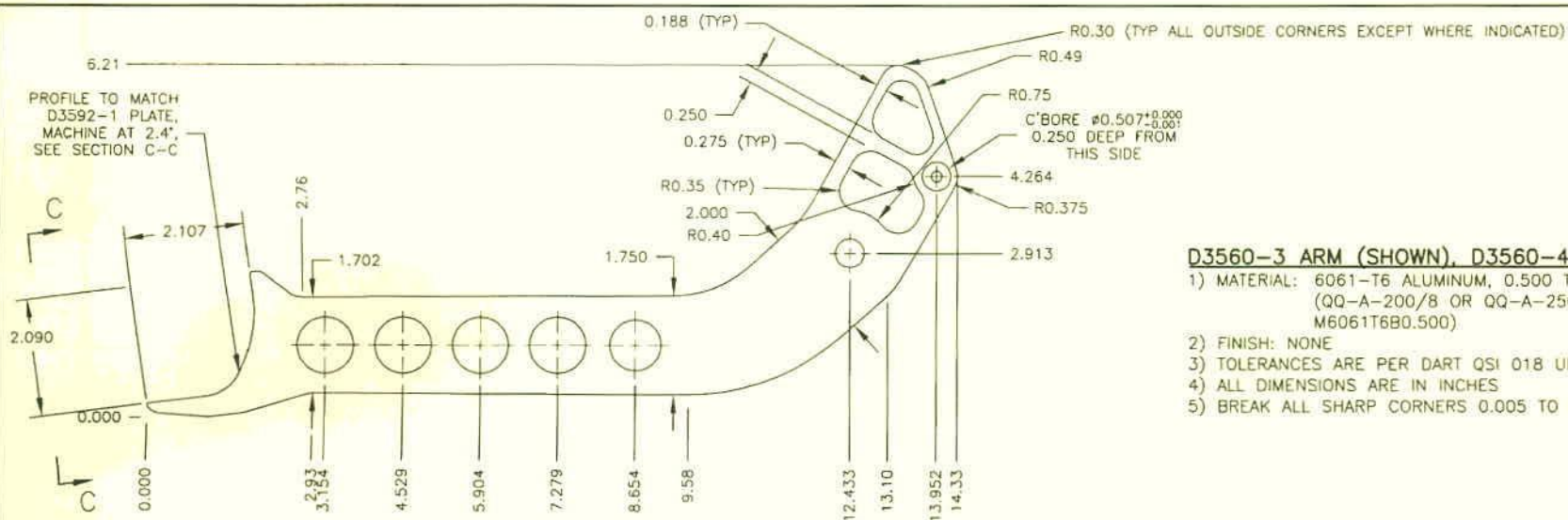
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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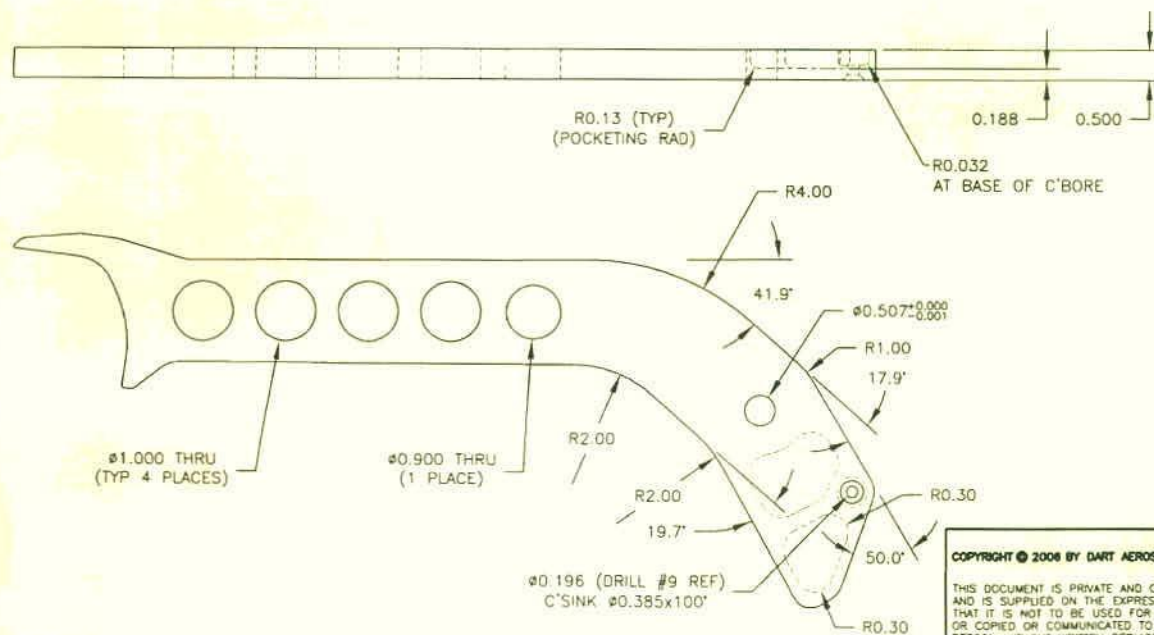
NOTE: Date & initial all entries



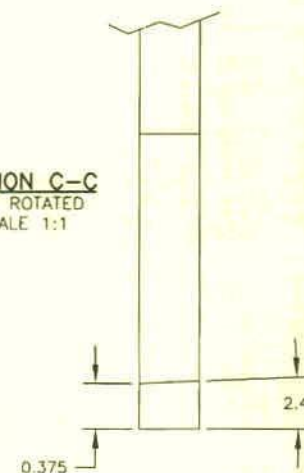


**D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.  
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



**RELEASED**  
07.06.19

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DESIGN	49	DRAWN BY	49	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	REV. C
DATE	07.06.19			D3560	SHEET 3 OF 3
				TITLE	SCALE
				ARM WELDMENT	1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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